

Date: Thursday, 2/1/2007 2:49:15 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STEP WELDMENT		
Job Number	30575					
Estimate Number	12577					
P.O. Number	N/A		Part Number	D3562042		
This Issue	2/1/2007	S.O. No.	N/A	Drawing Number	D3562 UNDER REVIEW	
Prsht Rev.	NC			Project Number	N/A	
First Issue	N/A	Type	LARGE FAB ASSY	Drawing Revision	A	
Previous Run	30493			Material	N/A	
Written By			Due Date	2/20/2007	Qty:	34
Checked & Approved By			Um:	Each		
Comment	Est Rev:A		New Issue	06-11-09	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>329607</u>			
		Check Material for any Dents or Defects	<i>11.02.03.19</i>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP <i>11.07.03.19</i>			
4.0	D2734	206 Step Endplate	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>329340</u>			
			<i>11.07.03.20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

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Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D35602 ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

1 D35602

Description Batch

Arm

830538 = 3

SL.07.03.20 3

6.0 D35604 ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

ARM

Batch: 330539 = 3

SL.07.03.20 3

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

Use DT8894 To Weld Arms

A/R Aluminum Rod M102237
M102225

2-Grind end cap welds flush as per Dwg D3562

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL.07.03.21 3

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and bevel aft end for welding.

SL.07.03.22 3

2-Weld as per Dwg D3562

a/r AL ROD Batch: M100237

SL.07.03.22 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-042 PAR #: NA Fault Category: Prod/Machines PRT NCR: Yes No DQA: D Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR: <u>150</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-04-05	17.0	Open Assembly parts were furnished to be mated; incorrectly <i>[Handwritten note]</i>	<i>J</i> <i>Asst Eng</i>	Scrap - destroy per NCR 150	<i>M</i> <i>07-04-05</i>	<i>J</i> <i>07-04-05</i>	<i>J</i> <i>07-04-05</i>	<i>J</i> <i>07-04-05</i>

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 30575

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/22 (3)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/22 (3)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M2E

07-03-22 (3)

15.0 POWDER COATING POWDER COATING



m103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/03/22 (3)

16.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M103980

a m 07/03/22 (3)

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mr 07-03-23 (3)

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

QC21

Do 810108

(3)
PLB

Job Completion



187-1011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

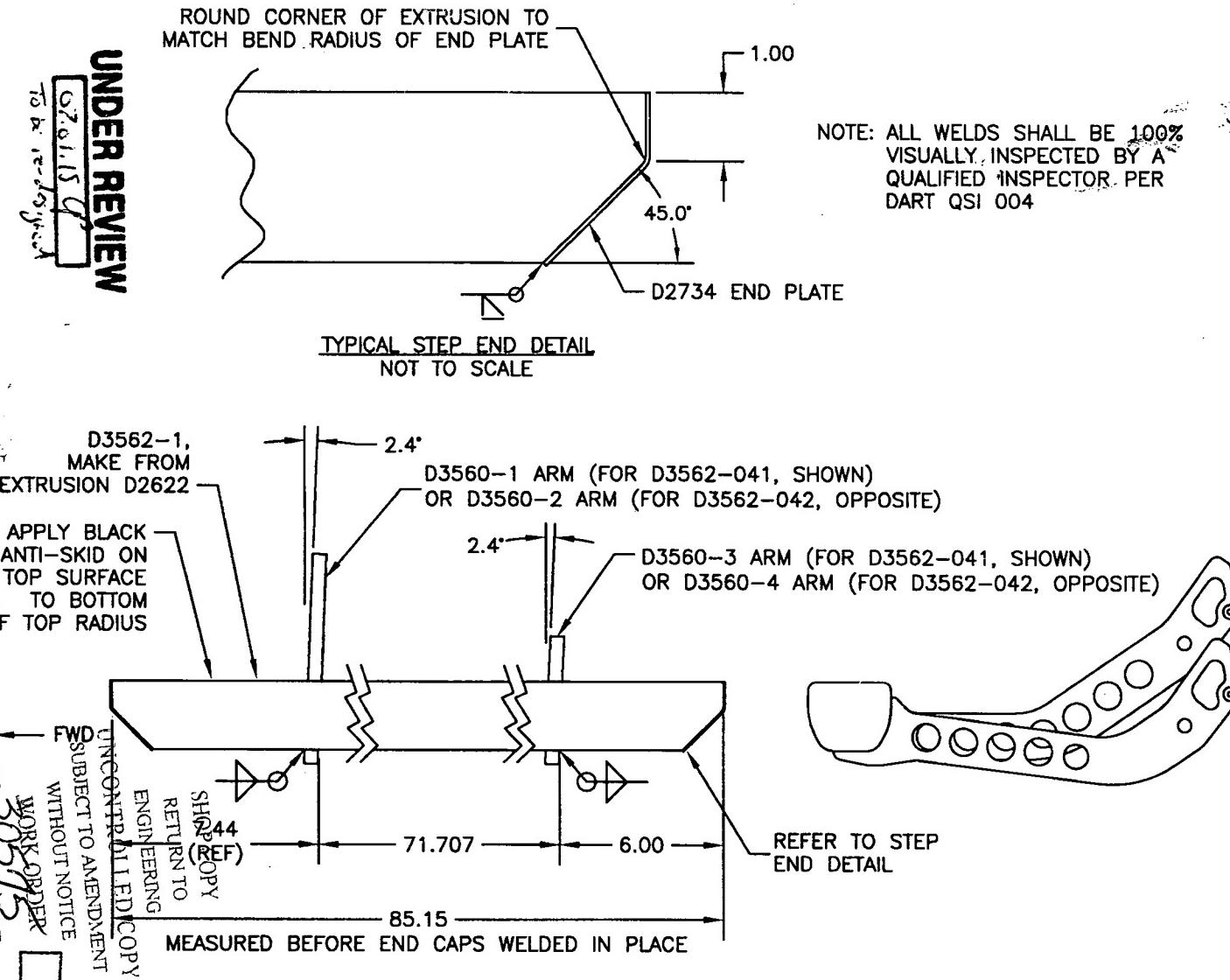
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3562
DATE		TITLE
06.09.26		STEP WELDMENT
		NTS
A	06.09.26	NEW ISSUE



**D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES